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D3564-11
Job Sheet 196520



Part No: D3564-11

Part Name: Wearplate Aft

Part Weight: 0 lbs

Job Created: 6/14/19

Due Date: 6/28/19

Type: Stock

Note: DWG REV E IPP Rev:A New Issue 07-03-08 ec IPP Rev:B As per Rev C 07-07-09 JLM IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC IPP Rev:D Comments revised on Step 5, 6 per B44656 09-02-06 KJ Verified By:

Ship Via:

Job Qty: 10 pcs

Status: New

Job Tracking No:

Created By: Marie Lajeunesse

Description:

Priority: Medium

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	10 pcs		6/28/19	0.17	1.74	Waterjet - Flow		06/19/07/30
120	QC 8	10 pcs		6/28/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
130	Small Fab - Brake NC - B4B	10 pcs		6/28/19	0.25	0.67	Small Fab - Brake - 1 - B4B		
							Small Fab - Brake - 2 -		

				B4B	
				Small Fab - Brake - 3 - B4B	
140 QC 5	10 pcs	6/28/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
150 Automated Welding - B4B	10 pcs	6/28/19	0.00 4.25	Automated Welding - 1 - B4B	
160 QC 10	10 pcs	6/28/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
170 QC 5	10 pcs	6/28/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
180 Spray Paint - 2 - B4B	10 pcs	6/28/19	0.00 1.00	Spray Paint - 1 - B4B	
				Spray Paint - 2 - B4B	
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
190 QC 5	10 pcs	6/28/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	

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				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	DAS
				QC 5 - 68	61
				QC 5 - 9	9-89
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
200 Packaging 3-1 - Stock - B4B 14 pcs THU 8-29-2019	6/28/19	0.00 0.00	→	Packaging 3 - 3 - B4B	FP002
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
210 QC 21 - SA 14 pcs THU 8-29-2019	6/28/19	0.00 0.00	→	QC 21 - SA - 21	FP002
				QC 21 - SA - 70	AUG 29 2019
				QC 21 - SA - 53	

Part Op 100 - 1-Cut D3564-1 as per Dwg D3564 Dwg Rev: E Prog Rev: E 2-Deburr if necessary

Descriptions: 120 - (QC8- Inspect parts - second check)
130 - Form on Brake as per Dwg D3564 using Jigs DT8179
140 - (QC5- Inspect part completeness to step on W/O)
150 - (Automated welding) 1- AUTOWELD AS PER DWG AND QSI004 8259 HARDCOAT BATCH: M139018
160 - (QC10- Inspect visual per QSI004- ground welds)
170 - (QC5- Inspect part completeness to step on W/O)
180 - (Spray Paint / NDT Room) APPLY COATING ON CONCAVE SURFACE AS PER DWG AND QSI005 (SEE NOTE 12 ON DWG) 9208066
190 - (QC5- Inspect part completeness to step on W/O)
200 - (Identify as per dwg & Stock Location: _____)
210 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	14.1000 sf (1.41 ea)	100-Waterjet - Flow - 1	51794100

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S16GA	14	295	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearshoe	3.227Inches ± 0.010	3.237 3.217		
2	Wearshoe	2.432Inches ± 0.010	2.442 2.422		
3	Wearshoe	2.500Inches ± 0.010	2.510 2.490		
4	Wearshoe	6.000Inches ± 0.010	6.010 5.990		
5	Wearshoe	12.104Inches ± 0.010	12.114 12.094		
6	Wearshoe	18.000Inches ± 0.010	18.010 17.990		
7	Wearshoe	18.000Inches ± 0.030	18.030 17.970		
8	Wearshoe	9.000Inches ± 0.030	9.030 8.970		
9	Wearshoe	11.500Inches ± 0.030	11.530 11.470		
10	Wearshoe	0.300Inches ± 0.010	0.310 0.290		
11	Wearshoe	0.300Inches ± 0.010	0.310 0.290		
12	Wearshoe	0.188Inches + 0.005 - 0.001	0.193 0.187		
13	Wearshoe	0.375Inches ± 0.010	0.385 0.365		
14	Wearshoe	0.063Inches ± 0.010	0.073 0.053		

Plex 6/14/19 8:06 AM Dart.lajeunesse.marie

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐							
Date :	Sequence #:	QTY Affected :		MRB (QS1042)							
Description Work Order Deviation				Disposition							
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐							
								Completed By			
								Lead hand / Supervisor			
								QC / QA Coordinator			